

Work Order ID 76514

November-16-11 10:48:20 AM

76514

Page 1

Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205 Skidtube
 Start Date: 16/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 18/11/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.C.O Date: 11/11/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2596	Rev D

100	Skidtubes	0.00							
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100

Skidtubes

Skidtubes

Memo

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

JW 11-11-16

110	Chemical Conversion Coat per QSI005 4.1	0.00							
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110

HandFinish

Hand Finishing

Memo

JW 11-11-16

120	QC5- Inspect part completeness to step on W/O	0.00							
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120

QC

Quality Control

Memo

2 0 BGI 11-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: LG	0.00				2	0	BE11-11-16	
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							11/11/17
140									
QC	Memo	0.00							
Quality Control									

11-11-17
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 76514

76514

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 16/11/2011

Required Date: 18/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	78.0000	1	2			
D2500-3-100									**				

Ext'n - 'I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

78

51957

2

66298

76

(2)

JW 11-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

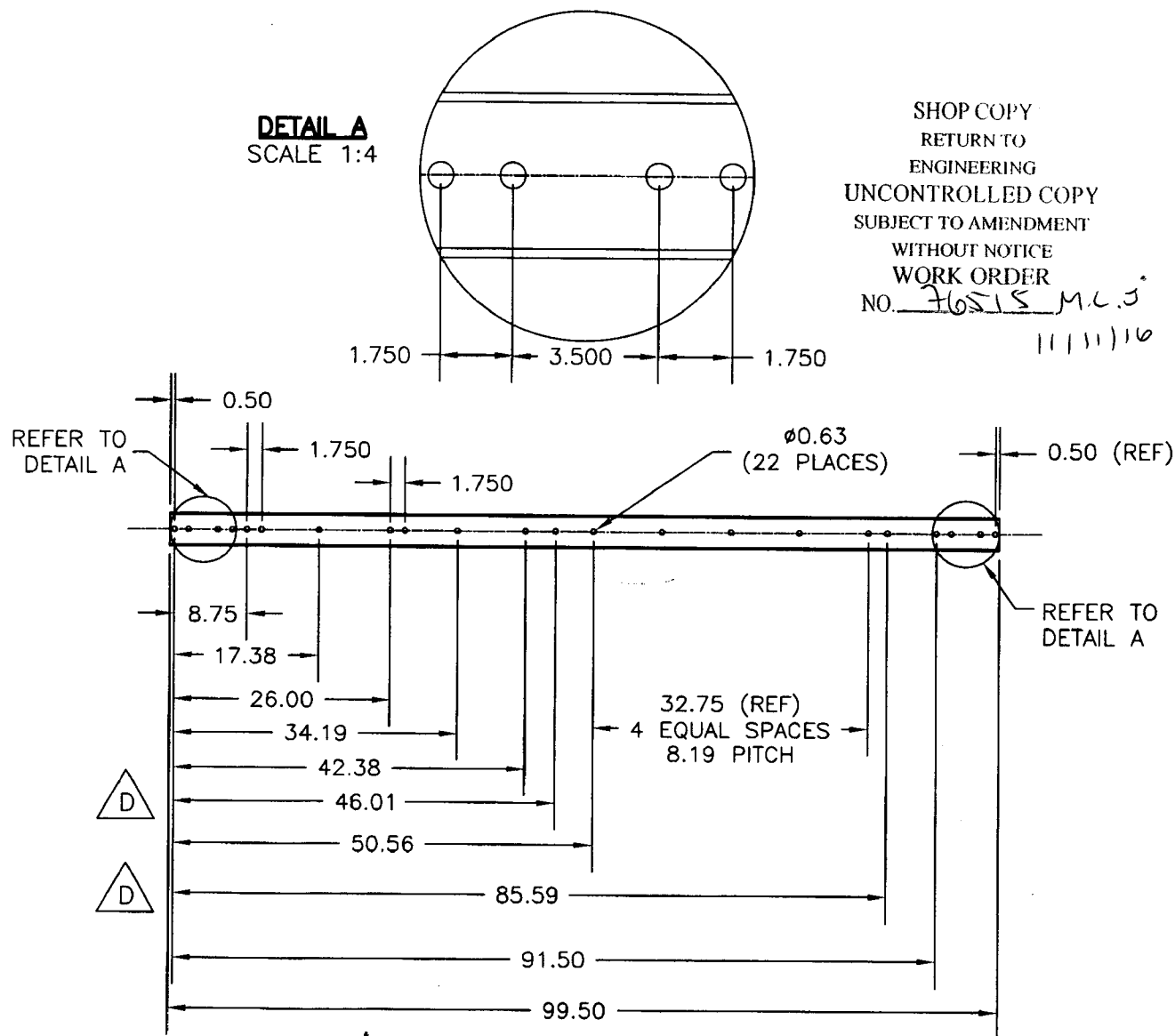
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



07 DEC 68

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76515 M.C.J.
1111116



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. D
DATE	07.04.17.			D2596	SHEET 1 OF 1
				TITLE	SCALE
				205 WEB	1:20
A		96.09.16		NEW ISSUE	
B		97.07.23		Ø0.63 HOLE WAS Ø0.56	
C		98.09.14		INCORPORATED DEO 9097	
D		07.04.17		INCORPORATED DEO 9183	

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